

Work Order ID 79004

Wednesday, January 18, 2012 11:30:27 AM

79004

Page 1

Item ID: D407-667-205

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Crosstube Aft

Stop ***NS2***

Start Date: 1/18/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/18/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference: QC21

Approvals: Process Plan: *WVF* Date: *12-9-18*

Tooling:

Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D407-667-245	Rev F/DEO
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290 QC5- Inspect part completeness to step on W/O 0.00

290

QC

Memo

0.00

Quality Control

PULL FROM STOCK D407-667-205 B 72742

UPON SHIPMENT, IT WAS REALIZED THAT QC21 WAS NOT DONE. W/O IS CLOSED SINCE BED OF NOVEMBER BUT CAN'T FIND W/O.

QC WILL INSPECT AND ENSURE EVERYTHING COMPLIES.

ATTACHED IS WORK ORDER SUMMARY WHICH SHOWS WHAT HAS BEEN PULLED AND WHO COMPLETED THE OPERATIONS

CLOSE UNDER NEW BATCH NUMBER
NEW LABELS REQU'D

295 Identify as per dwg & Stock Location: 0.00

295

Packaging

Memo

0.00

Packaging

C. O. 12/18/18

Work Order ID 79004***79004***

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Wednesday, January 18, 2012 11:30:27 AM

Item ID: D407-667-205

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Aft

Start Date: 1/18/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/18/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference: QC21


Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
310	QC21- Final Inspection - Work Order Release	0.00							
310									
QC	Memo	0.00							
Quality Control									

12/1/18 
ME 12-01-18

Work Order Summary

Wednesday, January 18, 2012 11:09:02 AM

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Criteria : Work Order ID: 72742 Item ID: D407-667-205 Product Family CROSSTUBES
 Work Order Start Dates 8/11/2011 to 8/11/2011 11:59:59 PM Work Order Required Dates 8/31/2011 to 8/31/2011 11:59:59 PM
 All References
 Work Order Status Costed

Work Order ID 72742 Required Qty 1.0000 Status Code Costed
 Item ID D407-667-205 Accepted Qty 1.0000 Scrap Qty 0.0000
 Item Name Crosstube Aft
 Current Acct Value \$3,244.481
 Start Date 8/11/2011 Required Date 8/31/2011 Completed Date 11/4/2011 3:13:50 PM

REFERENCE ONLY

Standard	** Actual **		** Acct. Value **	** Variance **	** Variance % **
Direct Costs	Total	Each	Each	Each	Each
Material	\$1,327.677	\$1,327.677	\$1,278.692	(\$48.985)	-3.83%
Labor	\$558.542	\$558.542	\$410.737	(\$147.805)	-35.99%
Outplant	\$60.583	\$60.583	\$70.100	\$9.517	13.58%
Variable Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Fixed Burden	\$1,297.827	\$1,297.827	\$881.200	(\$416.627)	-47.28%
Material Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
** Total **	\$3,244.630	\$3,244.630	\$2,640.729	(\$603.901)	

Item ID/Item Name	Required Qty	Issue Code	Issue Date	Issued Qty	Cost Amount
PO ID PO Line Nbr PO Receiver Date Domestic Unit PO Receipt Qty Domestic Received Amt Certification Standard					
Bolt PO Rout Seq ID	PO Vendor ID	VC-ACU002	11/3/2011	10.0000	\$1.432
AN5-10A Bolt	10/28/2011 9:12:44 AM \$58.4583 1.0000 \$58.458 119416				
AN5-34A Bolt	4.0000		11/3/2011	4.0000	\$2.345
D2873-043 Nut Plate Assembly	4.0000		11/3/2011	4.0000	\$2.208
D2873-045 Nut Plate Assembly	2.0000		11/4/2011	2.0000	\$56.247
D2894-1 2.750 Support	2.0000		11/4/2011	2.0000	\$66.194
D3190-1 Chafing Shield	1.0000		11/4/2011	1.0000	\$482.085
D3595-063-450 RUBBER CUSHION	2.0000		11/4/2011	2.0000	\$17.287
D407-667-205TRN Crosstube Turning Detail	2.0000		11/4/2011	2.0000	\$1.095
MS20601-AD4W8 RIVET	1.0000		10/20/2011	1.0000	\$1,607.864
	14.0000		11/4/2011	14.0000	\$6.775

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Work Order Summary

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MS21042L5

Nut

4.0000

11/3/2011

4.0000

\$1.758

MS21920-22

Clamp(per MIL-DTL-8783C)

4.0000

11/4/2011

4.0000

\$54.568

MS21920-25

Clamp(per MIL-DTL-8783C)

2.0000

11/4/2011

2.0000

\$60.955

NAS1149D0563J

Washer

18.0000

11/4/2011

18.0000

\$1.098

Total Matl Amts: \$2,361.910**Invoice Rout Seq ID****Invoice Vendor ID**

vc-acu002

Invoice ID**Invoice Line Nbr****Invoice Date****Invoice Unit Price****Invoice Qty****Invoice Amt**

0000090671

6

11/15/2011 10:50:33 AM

60.583333

1.0000

\$60.583

Work Center CNC Bend 1**Employee ID****Rout Seq ID****Labor Date****Setup Hours****Actual Setup Hours****Labor Hours****Actual Labor Hours****Nbr of WOs****Setup Amount****Labor Amount****Fix Burd Amount****Var Burd Amount****Total Amounts**

drou02

10/19/2011

120

0.84

0.42

0.00

0.00

2.00

\$9.059

\$0.000

\$17.998

\$0.000

\$27.057

10/20/2011

120

0.00

0.00

1.60

1.60

1.00

\$0.000

\$34.711

\$68.958

\$0.000

\$103.669

PAQU03

10/19/2011

120

0.00

0.00

0.50

0.25

2.00

\$0.000

\$5.448

\$10.824

\$0.000

\$16.272

10/20/2011

120

0.00

0.00

0.87

0.87

1.00

\$0.000

\$18.926

\$37.599

\$0.000

\$56.526

Total:

0.84

0.42

2.98

2.73

6.00

\$9.059

\$59.086

\$135.378

\$0.000

\$203.524

Work Center Crosstubes**Employee ID****Rout Seq ID****Labor Date****Setup Hours****Actual Setup Hours****Labor Hours****Actual Labor Hours****Nbr of WOs****Setup Amount****Labor Amount****Fix Burd Amount****Var Burd Amount****Total Amounts**

titl01

10/25/2011

140

0.00

0.00

2.90

1.45

2.00

\$0.000

\$27.313

\$68.659

\$0.000

\$95.971

11/1/2011

230

0.00

0.00

0.19

0.09

2.00

\$0.000

\$1.785

\$4.487

\$0.000

\$6.273

230

0.00

0.00

0.69

0.34

2.00

\$0.000

\$6.464

\$16.249

\$0.000

\$22.712

11/2/2011

230

0.00

0.00

2.61

1.31

2.00

\$0.000

\$24.576

\$61.780

\$0.000

\$86.356

230		0.00	0.00	0.44	0.22	2.00	\$0.000	\$4.161	\$10.460	\$0.000	\$14.621
230		0.00	0.00	2.74	1.37	2.00	\$0.000	\$25.744	\$64.715	\$0.000	\$90.459
230		0.00	0.00	0.86	0.43	2.00	\$0.000	\$8.129	\$20.436	\$0.000	\$28.565
<hr/>											
	11/3/2011										
230		0.00	0.00	2.00	1.00	2.00	\$0.000	\$18.781	\$47.211	\$0.000	\$65.991
<hr/>											
whit01	10/26/2011										
140		0.00	0.00	1.28	1.28	1.00	\$0.000	\$24.105	\$60.595	\$0.000	\$84.699
<hr/>											
Total:		0.00	0.00	13.71	7.50	17.00	\$0.000	\$141.057	\$354.591	\$0.000	\$495.648

Work Center SprayPaint

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
<hr/>												
titl01		<hr/>										
		10/28/2011	<hr/>									
210			0.00	0.00	2.30	1.15	2.00	\$0.000	\$21.669	\$54.473	\$0.000	\$76.142
<hr/>												
		10/29/2011	<hr/>									
210			0.00	0.00	0.52	0.13	4.00	\$0.000	\$2.457	\$6.176	\$0.000	\$8.633
210			0.00	0.00	1.16	0.58	2.00	\$0.000	\$10.869	\$27.322	\$0.000	\$38.190
			<hr/>									
Total:			0.00	0.00	3.98	1.86	8.00	\$0.000	\$34.995	\$87.971	\$0.000	\$122.965

5.0 PARTS LIST

5.1 HIGH GEAR CROSSTUBES

Item	Qty -101	Qty -201	Qty -103	Qty -203	Qty -105	Qty -205	Part Number	Description
	X						D206-667-101	CROSSTUBE INSTALLATION, 206A/B HIGH FWD
		X					D206-667-201	CROSSTUBE INSTALLATION, 206A/B HIGH AFT
			X				D206-667-103	CROSSTUBE INSTALLATION, 206L/L-1/L-3/L-4 HIGH FWD
				X			D206-667-203	CROSSTUBE INSTALLATION, 206L/L-1/L-3/L-4 HIGH AFT
					X		D407-667-105	CROSSTUBE INSTALLATION, 407 HIGH FWD
						X	D407-667-205	CROSSTUBE INSTALLATION, 407 HIGH AFT
1	1						D206-667-141	CROSSTUBE ASSEMBLY, 206A/B HIGH FWD
2		1					D206-667-241	CROSSTUBE ASSEMBLY, 206A/B HIGH AFT
3			1				D206-667-143	CROSSTUBE ASSEMBLY, 206L/L-1/L-3/L-4 HIGH FWD
4				1			D206-667-243	CROSSTUBE ASSEMBLY, 206L/L-1/L-3/L-4 HIGH AFT
5					1		D407-667-145	CROSSTUBE ASSEMBLY, 407 HIGH FWD
6						1	D407-667-245	CROSSTUBE ASSEMBLY, 407 HIGH AFT
10	*2	*2	*2		*2		D2891-1	SUPPORT
11				*2			D2892-1	SUPPORT
12						*1	D2894-1	SUPPORT
13	*4	*4	*4		*4		D3595-063-395	RUBBER CUSHION
14				*4			D3595-063-450	RUBBER CUSHION
15						*2	D3595-075-430	RUBBER CUSHION
16	*4	*4	*4		*4		MS21920-20	CLAMP
17				*4		*4	MS21920-22	CLAMP
18						*2	MS21920-25	CLAMP (OR MS21920-24)
19	4	4	4		4		AN5-32A	BOLT
20				4		(4)	AN5-34A	BOLT
21	4	4	4	4	4	(4)	MS21042L5	NUT (OR MS21042-5)
22	8	8	8	8	8	(8)	NAS1149C0563J	WASHER (OR AN960JD516)
23						*2	D3190-1	CHAFING SHIELD
40	*2		*2	*2	*2	*2	D2873-043	NUT PLATE
41	*2		*2	*2	*2	*2	D2873-045	NUT PLATE
42		2					D2872-043	NUT PLATE
43		2					D2872-045	NUT PLATE
44	10		10				AN5-7A	BOLT
45		10		10	10	(10)	AN5-10A	BOLT
46	4	10	4		4		AN5-30A	BOLT
47				4		(4)	AN5-32A	BOLT
48			12				AN970-4	WASHER (OPTIONAL)
49		6				(6)	MS21042L5	NUT (OR MS21042-5)
50	10	12	10	10	10	(10)	NAS1149C0563J	WASHER (OR AN960JD516)
60		1					D3039-3	CENTER DRILL (TOOLING, NOT INSTALLED)

*REFERENCE ONLY. PARTS ARE INCLUDED IN D206-667-141/-143/-241/-243 & D407-667-145/-245 ASSEMBLIES ABOVE

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